

Work Order ID 74826

74826

Page 1

Friday, October 07, 2011 10:36:52 AM

Item ID: D3883-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outboard RH
 Start Date: 10/7/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/14/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: 11-10-11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	C								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Program Batch No. 74826
 Double check by: ps
 1-Machine Step No 1 per Folio FA817 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA817 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA817 and inspect per Dimension Sheets
 110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 12-06-05		(H)			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	2	(SP) 12/05/05	
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00		9:20 3200F 9:50		4X		M.T 12/06/08	

M121134

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Page 3

Item ID: D3883-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Outboard RH

Start Date: 10/7/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

4 0 12-06-08

160

Identify as per dwg & Stock Location: STY25 0.00***160***

Packaging

Memo

0.00

Packaging

4 0 12-06-08

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/6/11 JF

MF
12-06-08

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Picklist Print

Friday, October 07, 2011 10:37:03 AM

Page 1

Work Order ID: 74826

Parent Item: D3883-2

Start Date: 10/7/2011

Required Date: 10/14/2011

Parent Item Name: Saddle, Outboard RH

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015 Saddle Billet		Manufactured	No				Each	0.0000		4			

B74800 x 4 emk 12/06/09

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DART AEROSPACE LTD		Work Order: 74826
Description: Saddle, Outboard, RH.		Part Number: D3883-2
Inspection Dwg: D3883	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.645	0.652	0.650	0.651		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.259	0.259	0.259	0.259		
F	0.605	0.625		0.611	0.616	0.619	0.619		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.006	2.004	2.003	2.005		
J	0.140	0.165		0.145	0.153	0.154	0.154		
K	0.240	0.260		0.241	0.252	0.253	0.253		
L	0.115	0.135		0.125	0.123	0.123	0.122		
M	0.140	0.165		0.145	0.153	0.154	0.152		
N	0.720	0.780		0.765	0.770	0.770	0.770		
O	0.240	0.260		0.247	0.249	0.250	0.249		
P	0.110	0.140		0.140	0.140	0.140	0.140		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	2.825	2.885		2.866	2.870	2.870	2.870		
S	0.316	0.321		0.316	0.316	0.316	0.316		
T	0.990	1.010		1.005	1.000	1.000	1.000		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.002	6.002	6.007	6.007		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		0.503	0.501	0.501	0.500		
Y	1.220	1.280		1.253	1.253	1.253	1.253		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		0.314	0.314	0.314	0.314		
AB	0.020	0.040		0.034	0.034	0.034	0.034		
AC	0.760	0.765		0.760	0.760	0.760	0.760		
AD	0.215	0.220		0.215	0.219	0.219	0.219		
AE	1.265	1.285		1.270	1.268	1.270	1.2705		
AF									
Accept/Reject									

Measured by: <i>CHL</i>	A.A.
Date: 12/06/01	12/06/02

Audited by: <i>SL</i>
Date: 12-06-05

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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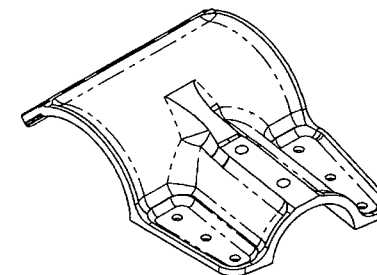
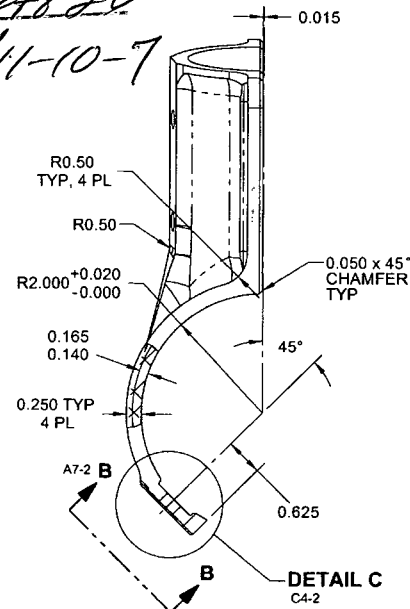
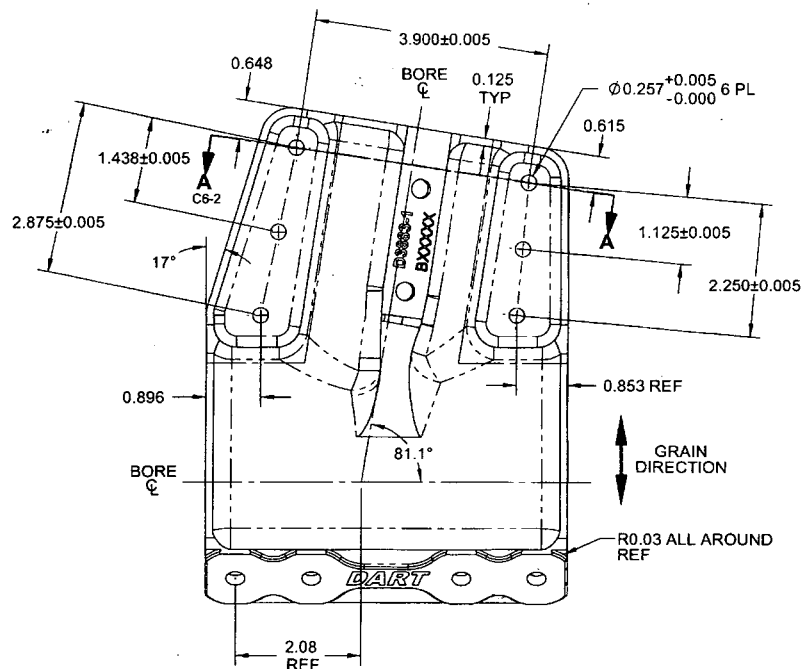
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74826
11-10-7



D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

RELEASED
2009-11-19
MP

C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3883	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	OUTBOARD SADDLE	NTS
DATE	09.11.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

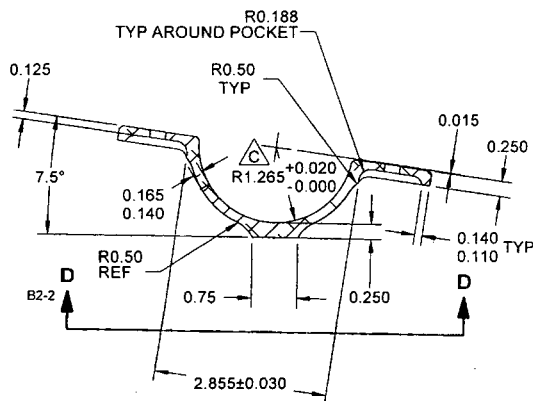
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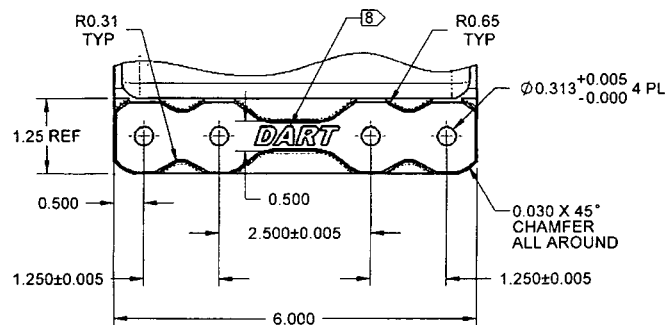
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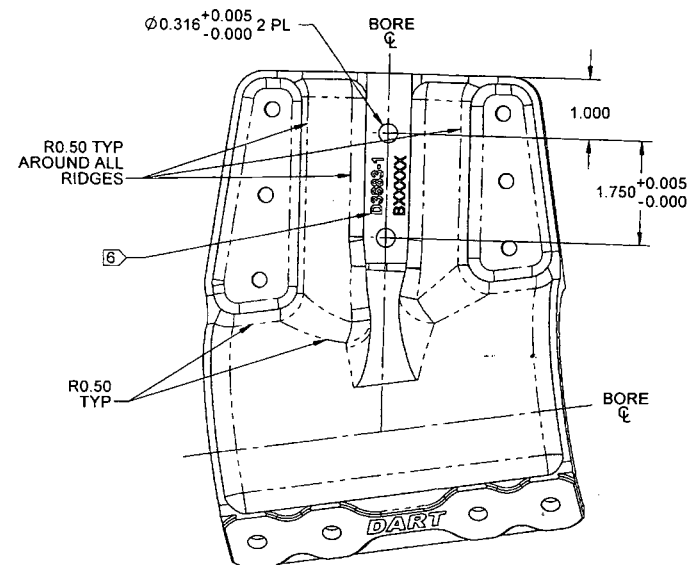
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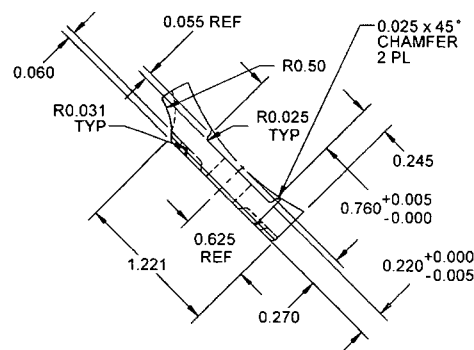
SECTION A-A C7-1



VIEW B-B B4-1
(ROTATED FOR CLARITY)



VIEW D-D C7-2



DETAIL C B3-1
SCALE 2X

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3883	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD SADDLE	NTS
DATE	09.11.09	<small> COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

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